



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

SWA10A-400
Job Sheet 191458



Part No: SWA10A-400

Job Qty: 10 pcs

Part Name: Thrust Washer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/1/19

Job Tracking No:

Due Date: 3/20/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG SWA10A-400 Rev 4 IPP Rev A 18.01.09 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	SL-2500Y - 1	10 pcs	3/20/19	3/20/19	0.00	2.50	SL-2500Y - 1		DAS 56 9-89 2019-03-03
120	QC 2	10 pcs	3/20/19	3/20/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com

Date: 03/03/19



Container No: S158399
Part: SWA10A - 400
Job No: 191458
Serial No/Batch: S158399
Revision: 4
Inspector:
Exp Date:
Instructions:

Plex 3/1/19 10:46 AM Dart.lajeunesse.marie

Plex 3/1/19 10:46 AM Dart.lajeunesse.marie

150 QC 21 - SA	10 pcs	3/20/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	DAG
				QC 21 - SA - 53	21 MAR 18 2019

Part Op 110 - SL2500Y (MORI SL2500Y LATHE) 1-Machine as per FOLIO FB722 FOLIO REV: AA 3-55 DWG REV: 34

Descriptions: 2-Deburr

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - (Identify as per dwg & Stock Location: _____)

150 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
MT-BRONZE-C63000-R2.500	Bronze C63000 Round Bar 2.500"	.2500 ft (.025 ea)	110-SL-2500Y - 1	5072 875

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-SL-2500Y - 1	MT-BRONZE-C63000-R2.500	0	3	0

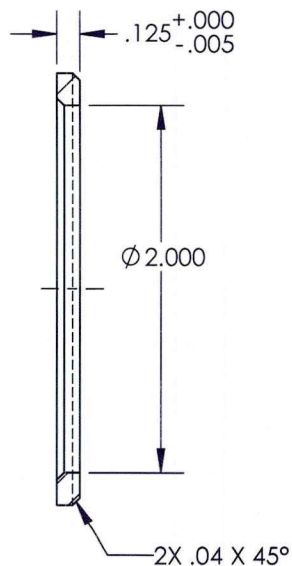
NAT 009-B

Part Specifications
Specifications could not be found.

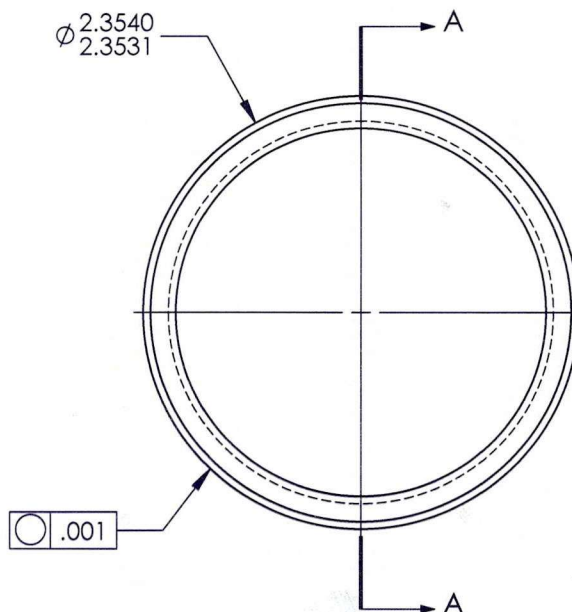
Plex 3/1/19 10:46 AM Dart.lajeunesse.marie

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		AS DRAWN BY CANAM	11/12/2012	JAG	
3		CH'D TOLERANCE ON OD FROM Ø2.352 +.003/-0.001	11/16/2012	JAG	
4	16-0249	CH'D DIM WAS 62.3538/2.3533 IS Ø2.3540/2.2331, ADDED DIM Ø .001	12/2/2016	RJC	JAG



SECTION A-A



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 191458465
1903-01

DART AEROSPACE	
TITLE THRUST WASHER	
DWG NO. SWA10A-400	REV 4
MAT'L AL-BRONZE 630	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125/
DRAWN BY: CANAM	1. BREAK ALL SHARP EDGES .015 X 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	
SCALE 1:1	DATE 1/22/2002 SHEET 1 OF 1

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			SWA10A-400	1	THRUST WASHER	AL-BRONZE 630	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					